

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023250**Date Inspected:** 01-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

**OBG Trial Assembly Area**

This QA Inspector performed document review of "Team China-Request For Information (TC-RFI)" document #TC-RFI-0082R0. This QA Inspector performed a visual observation associated with the documentation to determine if the work outlined had been completed or is still in process. The information has been updated on the spread sheet "Copy of TC-RFI\_PMIV\_LOG updated 4-29-11" located on the Z drive under; Z:\TEAM OBG\TC RFI VERIFICATION. See the spread sheet comments section for further information. This QA inspector has also performed photo documentation of RFI-0082R0 which has been placed in the corresponding TC-RFI folder.

FCAW welding of weld joints SA3060-002-002, 008; SA3060-001-002 located on PCMK OBG Segment 13CE, kink splice sub-assemblies. Welder was identified as 050977. QC was identified as ABF CWI Bao Qian (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhan Hai Feng (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2231-ESAB as verbally identified by QCA1. See photos below of welding operation in progress.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As noted above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

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**Inspected By:** Goulet, George

Quality Assurance Inspector

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**Reviewed By:** Riley, Ken

QA Reviewer